

Date: Thursday, 24/07/2008 3:13:55 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-558-041
Job Number	: 40748-2	Part Number	: D206558041
Estimate Number	: 10804	Drawing Number	: ECN08-504
P.O. Number	:	Project Number	:
This Issue	: 24/07/2008 S.O. No. :	Drawing Revision	:
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 05/08/2008
Previous Run	: 00015	Qty:	18 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3X D206-558-041 B 38580 ✓ FFx3 08-07-30

PULL FROM STOCK

3 X D206-558-041 B39281

10 X D206-558-041 B39398 ✓

5 X D206-558-041 B39399 ✓

FFx10 } 08-07-30
FFx5 }

2.0	D206558041	Single Cargo Mirror Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)
 Single Cargo Mirror Assembly

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

D2057 PLUG

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

DISCARD HARDWARE

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

FF 08-07-30

— FF 08-07-30

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 31.5006 f(s)
304 RD Tube .500 x .049W *per ECN 08-504*
304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012
(M04TR0.500W035) *049*
Identify as D2065. Batch *108324*
Note: 1 end only *u* *FF 08-07-31* **(10)**

take 10x D2065 from B 40580

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE *049*
Punch 1/2" OD x .035" Wall AISI

Signed for SR.

FF 08-07-31 - (10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Cut to length as per Dwg D2065
Bend as per Dwg D2065 and template D2065T1
Flatten the end on Hydraulic press using Dt 8545
Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.
Deburr.

FF 08-07-31 **(10)**

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/31 (+10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

102316

(10x)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*11:00
320
11:30*

M-h

08/07/31

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Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/07/31 (10)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-558

FF 08-08-01 (9)
Last page

USING ORIGINAL COMPONENTS
AND NEW HARDWARE:

FF 08-08-01 (9)

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 72.0000 Each(s)
Washer 36

Pick:

Qty Part Number

Description

Batch

4 AN960JD10

Washer

M100550

FF 08-08-01 (9)

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 26.0000 Each(s)
Nut 18

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

M107665

FF 08-08-01 (9)

or MS21042-3

13.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)
Screw 18

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18

Screw

M100161

FF 08-08-01 (9)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/01 (19)

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Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR
ORIGINAL KITS TO BE INCLUDED.

08/08/09 (+9)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP
USING NEW B/N @ CHG 007
NEW LABELS REQUIRED
ADD PAPERWORK DSI 9416

08/08/09

08/08/01 (+9)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



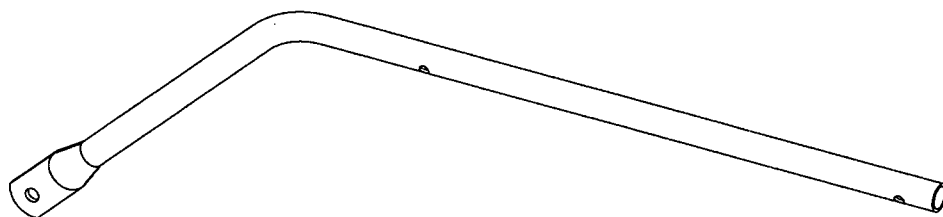
Comment: FINAL INSPECTION/W/O RELEASE

08/08/01 (+9)

Job Completion



mf 08-08-01



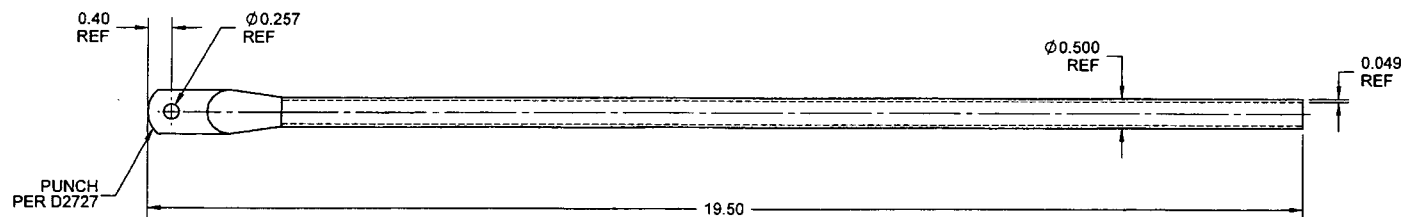
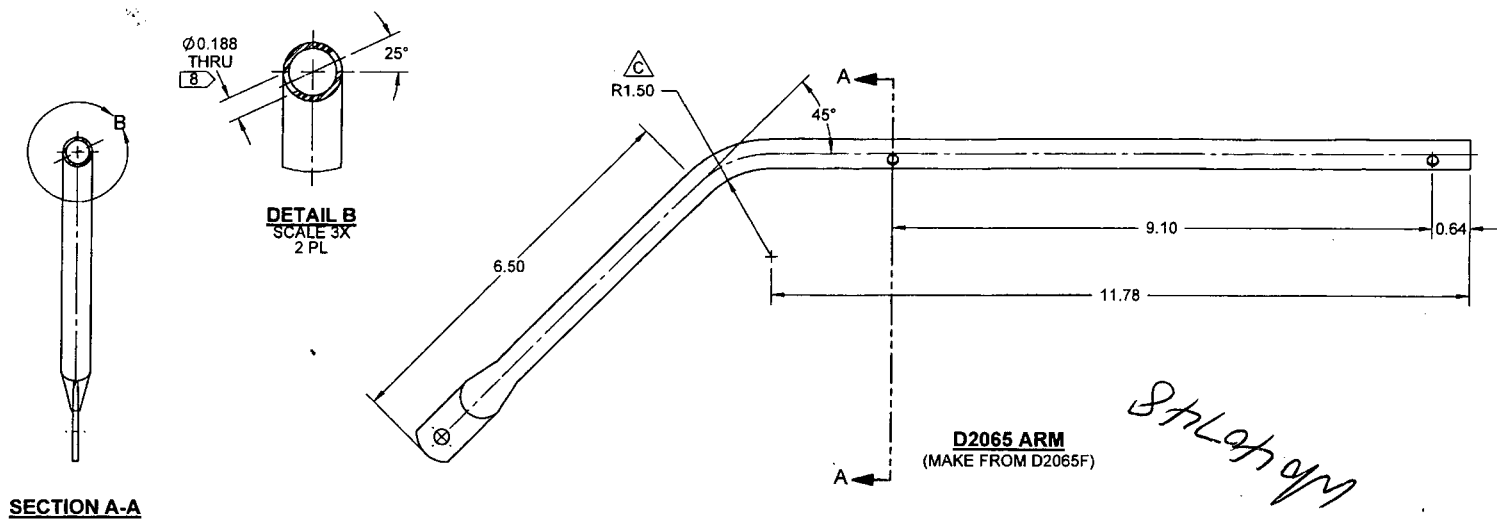
D2065 ARM

w/o
40248

RELEASED
08-07-23.117



C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø 0.500 X 0.048 WALL WAS Ø 0.500 X 0.035 WALL (ZN A5-2); REASON: Ø 0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2065 REV. C SHEET 1 OF 2 TITLE ARM SCALE NTS COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.13		

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL $\phi 0.188$ AFTER BENDING


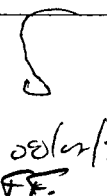


DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	DS	D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD	
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RELEASED
08.07.23.18

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-558-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 08.08.21
 QA: N/C Closed: _____ Date: _____

NCR: <u>40748</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/21	# 10.0	During Disassembly the 22057 Plugs were not saveable Due to the inside Decal of the tubing changing		Scrap all plugs with Arms and Decal Pull from stock B# <u>340040</u>	08/07/21 FF	 08/07/21 FF		 08/07/21

NOTE: Date & initial all entries

DART
Dart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY, ON, CANADA K6A 1K7

TC APPROVAL # 09-89
TEL: 1-613-632-5200

P/N	D206-558-041	CHG	CHG006
DESC.	Single Cargo Mirror Assy	STC	SH92-17
LOT	B38580	STC	SH1031NE
MODEL	206A/B/L/L1/L3/L4/407	STC	

MADE IN CANADA D2729-1

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P/N	D206-558-041	CHG	CHG006
DESC.	Single Cargo Mirror Assy	STC	SH92-17
LOT	B39399	STC	SH1031NE
MODEL	206A/B/L/L1/L3/L4/407	STC	

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LOT	B39398	STC	SH1031NE
MODEL	206A/B/L/L1/L3/L4/407	STC	

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